

Work Order ID 91997

\*91997\*

Page 1

January 15, 2013 9:31:39 AM

Item ID: D3885-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Standard Web

Stop

\*NS2\*

Start Date: 10/19/12 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

*CL*

Date: 13/01/15

Tooling:

Date:

Run

Start

\*NR1\*

OC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Work Order ID	Description	Quantity	Unit Price	Total Price	Material Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	-------------	----------	------------	-------------	---------------	------------	------------	---------------	-------------

Draw Nbr	Revision Nbr
D3885	B

100 0.00

\*100\*

Purchasing

Memo

0.00

Purchasing

Purchasing

Issue P/O:

18242

Supplier: George A. Wright & Son Ltd.

Machine as per Dwg D3885

Conformity sheet required

*CL* 13/01/15

*S.*

*70*

110

Receive & Inspect for Damage & Mat'l Certs

0.00

\*110\*

Packaging

Memo

0.00

Packaging

*Sx*

*Sx*  
13-4-02

*09134*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
<b>Landing Gear</b>		<b>General</b>		<b>Grain</b>		<b>Ovalized</b>		<b>Pressure/Forced</b>	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Other	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset		
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration			<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

# Work Order ID 91997

**\*91997\***

Page 2

January 15, 2013 9:31:39 AM

Item ID: D3885-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Standard Web  
 Start Date: 10/19/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 11/09/12 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00				S			
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							

27  
1348

See w/o  
29/34

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

# Work Order ID 91997

**\*91997\***

Page 3

January 15, 2013 9:31:39 AM

Item ID: D3885-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Standard Web  
 Start Date: 10/19/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 11/09/12 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*see also 99134*

*W 13-04-16*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other		

# Picklist Print

January 15, 2013 9:31:39 AM

Page 1

Work Order ID: 91997

Parent Item: D3885-3

Parent Item Name: Standard Web

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3885-3P Standard Web		Purchased	No				Each	0.0000		10.5			
D3882-1-130 Extrusion "I" Beam		Manufactured	No			110	Each	21.0000	1	10.5			

SPB-402

CS 13/01/18

Location	Loc Qty	Loc Code
HALL	16	
51826	16	
LG	5	
51826	5	

~~93832~~

~~5~~

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  <div style="display: flex; justify-content: space-around;"> <div> <input type="checkbox"/> Rework  <input type="checkbox"/> Scrap  <input type="checkbox"/> Use-as-is  <input type="checkbox"/> Work Order Update         </div> <div> <input type="checkbox"/> Skid-tube  <input type="checkbox"/> Machining  <input type="checkbox"/> Thermoforming  <input type="checkbox"/> Large Fab         </div> <div> <input type="checkbox"/> Crosstube  <input type="checkbox"/> Small Fab  <input type="checkbox"/> Finishing  <input type="checkbox"/> Composite         </div> <div> <input type="checkbox"/> Water Jet  <input type="checkbox"/> Prod. Eng. Coord.  <input type="checkbox"/> Rec/Store/Packaging  <input type="checkbox"/> Supplier         </div> <div> <input type="checkbox"/> Engineering  <input type="checkbox"/> Quality  <input type="checkbox"/> Other         </div> </div>
--	--

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



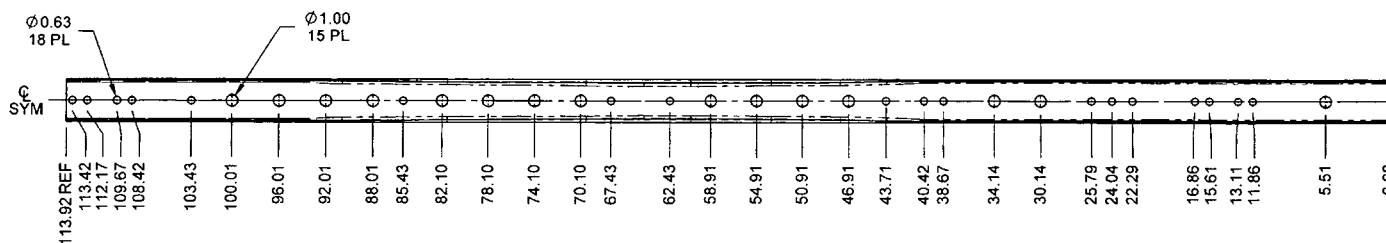
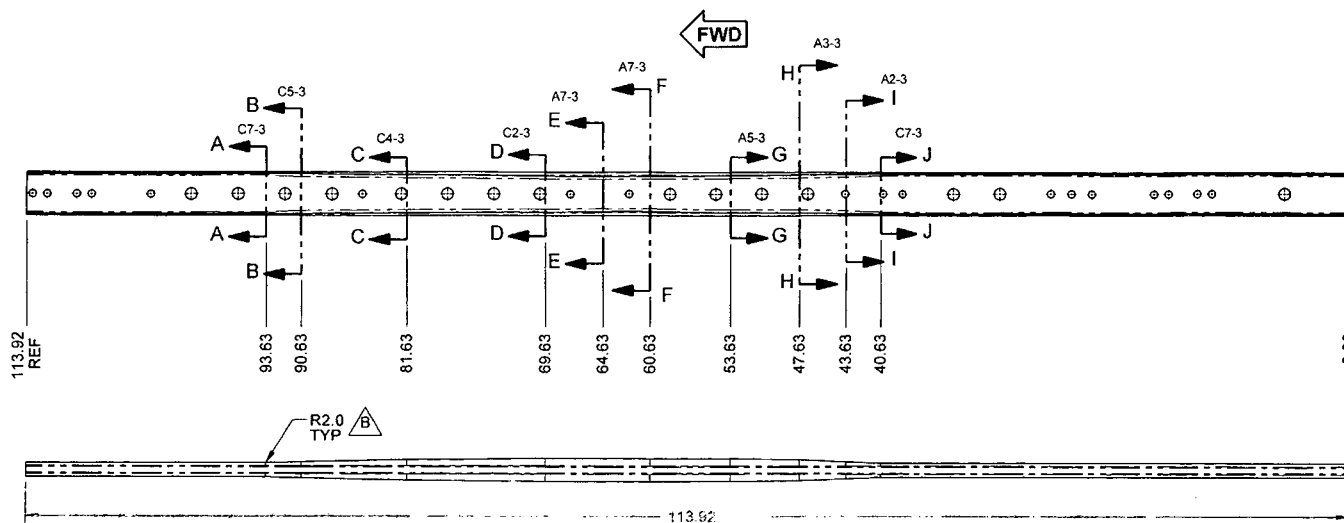
**D3885-1 STANDARD WEB**

**D3885-3 FLOAT WEB**

C213/0115  
W10.91997

**RELEASED**  
9/15/11

B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5); ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



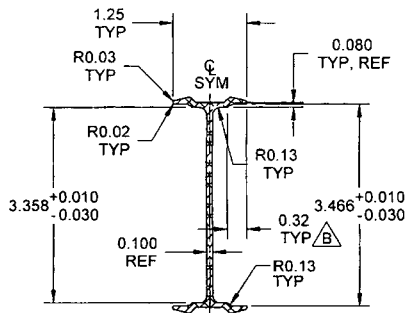
# **D3885-1 STANDARD WEB**

## **D3885-1 NOTES:**

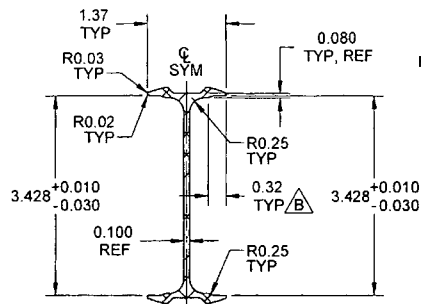
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.51 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3885</b>	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>WEB</b>	NTS
DATE	09.06.30	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

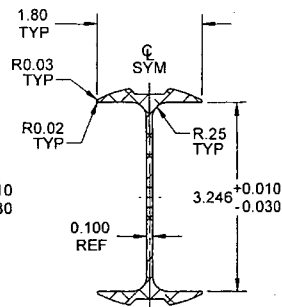
**RELEASED**  
*09/27/15*



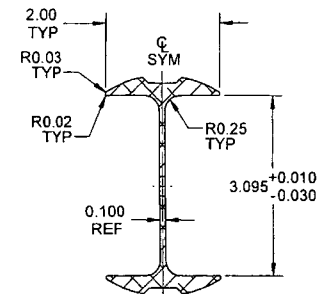
**SECTION A-A  
& SECTION J-J**  
SCALE 5X



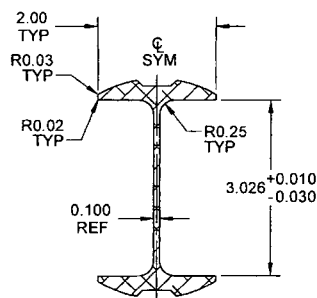
**SECTION B-B**  
SCALE 5X



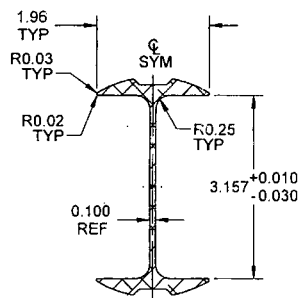
**SECTION C-C**  
SCALE 5X



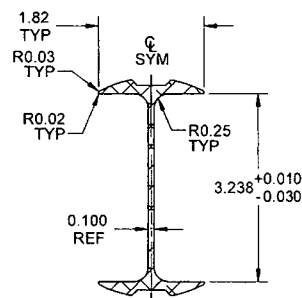
**SECTION D-D**  
SCALE 5X



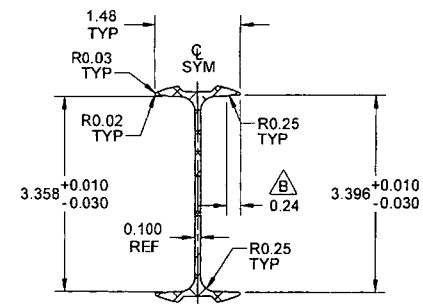
**SECTION E-E  
& SECTION F-F**  
SCALE 5X



**SECTION G-G**  
SCALE 5X



**SECTION H-H**  
SCALE 5X

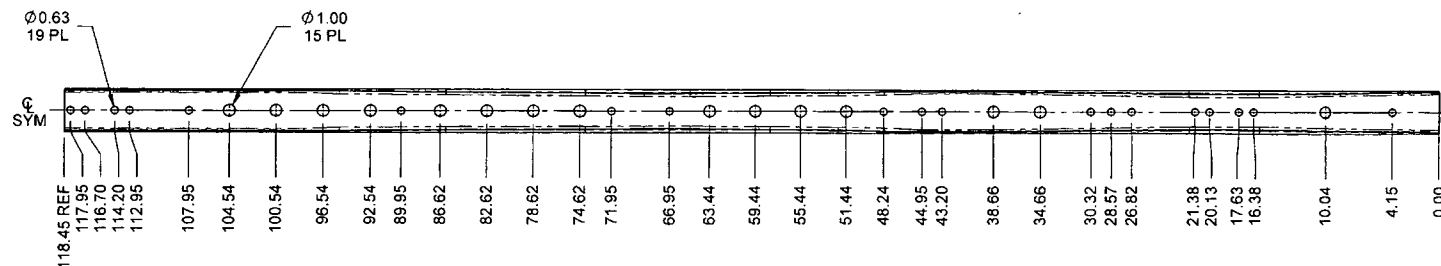
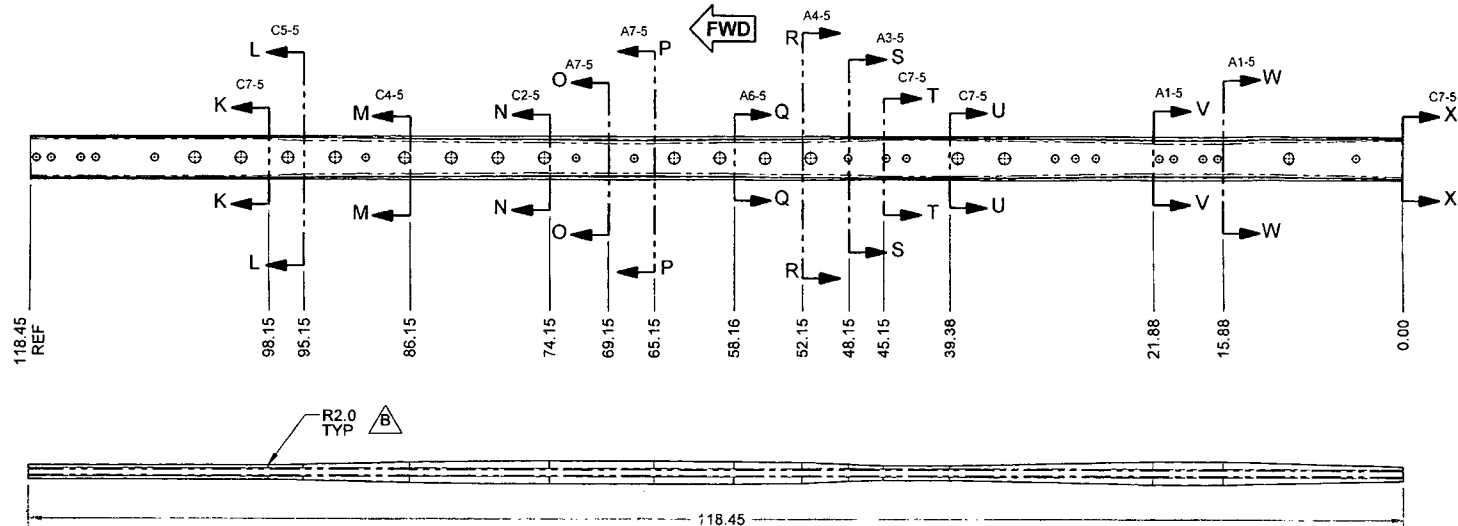


**SECTION I-I**  
SCALE 5X

**D3885-1 STANDARD WEB SECTION VIEWS**

**RELEASED**  
09/07/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, VA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



### D3885-3 FLOAT WEB

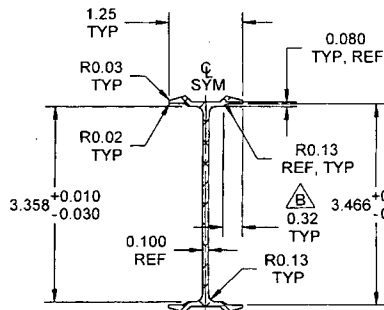
**RELEASED**  
09/07/15 AN

#### D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 10.14 lbs

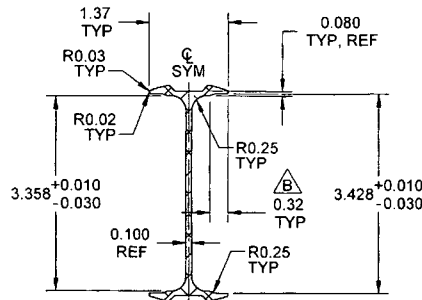
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

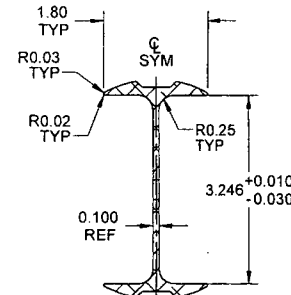


**SECTION K-K  
& SECTION T-T  
& SECTION U-U  
& SECTION X-X**  
SCALE 5X

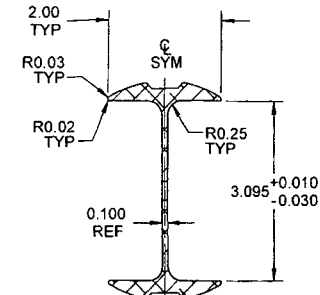
D7-4  
D4-4  
D3-4  
D1-4



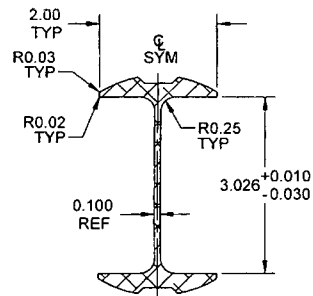
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SCALE 5X



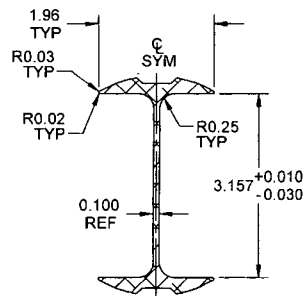
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SCALE 5X



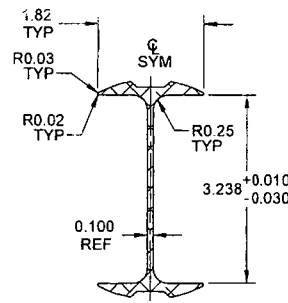
**SECTION N-N** D5-4  
SCALE 5X



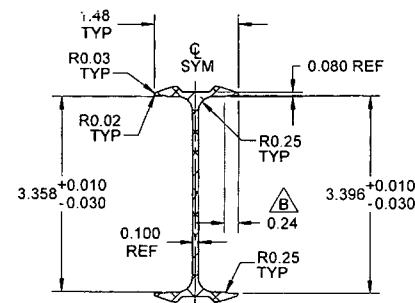
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& SECTION P-P** D5-4  
SCALE 5X



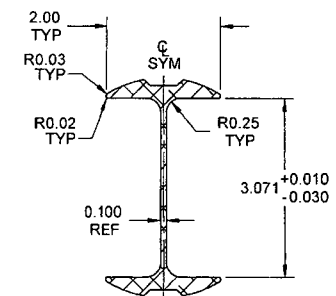
**SECTION Q-Q** D4-4  
SCALE 5X



**SECTION R-R** D4-4  
SCALE 5X



**SECTION S-S** D4-4  
SCALE 5X



**SECTION V-V  
& SECTION W-W** D3-4  
D2-4  
SCALE 5X

**RELEASED**  
8/17/54

**D3885-3 FLOAT WEB SECTION VIEWS**

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1





600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

## CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: March 26, 2013	
		P.O.# PO18242	
		WEJAY JOB# 36044C	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-3 'Float Web'	5	Machined complete per drawing req'ts.	D3885 / rev. B
Note: 1) Material supplied by Dart Aerospace. 2) Inspection report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

**Clifford Smith**

Authorized Q.A. Signatory



600 O'CONNOR DRIVE  
KINGSTON, ONTARIO  
K7P 1N3

# INSPECTION / TEST REPORT

JOB No. 36044C

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# F018242

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885

REV. B

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

QUANTITY  
REC'D: 5

ACCEPT: 5

REJECT: -

N.C.R.# -

DATE:

MARCH 26, 2013

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	--------------------------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	Hole, Diameter .63"	19 places	+.008/- .001		O.K.	2	Acc. 5
2	Hole, Diameter 1.00"	15 places	+.010/- .001		O.K.	2	"
3	4.15"		+/- .03		O.K.	2	"
4	10.04"		+/- .03		O.K.	2	"
5	16.38"		+/- .03		O.K.	2	"
6	17.63"		+/- .03		O.K.	2	"
7	20.13"		+/- .03		O.K.	2	"
8	21.38"		+/- .03		O.K.	2	"
9	26.82"		+/- .03		O.K.	2	"
10	28.57"		+/- .03		O.K.	2	"
11	30.32"		+/- .03		O.K.	2	"
12	34.66"		+/- .03		O.K.	2	"
13	38.66"		+/- .03		O.K.	2	"
14	43.20"		+/- .03		O.K.	2	"
15	44.95"		+/- .03		O.K.	2	"
16	48.24"		+/- .03		O.K.	2	"
17	51.44"		+/- .03		O.K.	2	"
18	55.44"		+/- .03		O.K.	2	"
19	59.44"		+/- .03		O.K.	2	"
20	63.44"		+/- .03		O.K.	2	"
21	66.95"		+/- .03		O.K.	2	"
22	71.95"		+/- .03		O.K.	2	"
23	74.62"		+/- .03		O.K.	2	"
24	78.62"		+/- .03		O.K.	2	"
25	82.62"		+/- .03		O.K.	2	"
26	86.62"		+/- .03		O.K.	2	"
27	89.95"		+/- .03		O.K.	2	"
28	92.54"		+/- .03		O.K.	2	"
29	96.54"		+/- .03		O.K.	2	"
30	100.54"		+/- .03		O.K.	2	"
31	104.54"		+/- .03		O.K.	2	"
32	107.95"		+/- .03		O.K.	2	"
33	112.95"		+/- .03		O.K.	2	"
34	114.20"		+/- .03		O.K.	2	"
35	116.70"		+/- .03		O.K.	2	"



# INSPECTION / TEST REPORT

JOB No.

36044C

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. 9018242

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
----------	----------------	---------	-----------	--------------	--------	------------	---------------------------------

36	117.95"		+/- .03		O.K.	2	Acc. 5
37	1.25" TYP	Section K-K,T-T,U-U,X-X			O.K.	2	"
38	R.03" TYP				O.K.	2	"
39	R.02" TYP				O.K.	2	"
40	3.358"		+ .010/- .030		O.K.	5	"
41	R.13" TYP				O.K.	2	"
42	.32" TYP				O.K.	2	"
43	3.466"		+ .010/- .030		O.K.	5	"
44	R.13" TYP				O.K.	2	"
45	.080 TYP, REF				O.K.	2	"
46	1.37" TYP	Section L-L			O.K.	2	"
47	R.03" TYP				O.K.	2	"
48	R.02" TYP				O.K.	2	"
49	3.358"		+ .010/- .030		O.K.	5	"
50	R.25" TYP				O.K.	2	"
51	.32" TYP				O.K.	2	"
52	R.25" TYP				O.K.	2	"
53	3.428"		+ .010/- .030		O.K.	5	"
54	1.80" TYP	Section M-M			O.K.	2	"
55	R.03" TYP				O.K.	2	"
56	R.02" TYP				O.K.	2	"
57	3.246"		+ .010/- .030		O.K.	5	"
58	R.25" TYP				O.K.	2	"
59	2.00" TYP	Section N-N			O.K.	2	"
60	R.03" TYP				O.K.	2	"
61	R.02" TYP				O.K.	2	"
62	3.095"		+ .010/- .030		O.K.	5	"
63	R.25" TYP				O.K.	2	"
64	2.00" TYP	Section O-O,P-P			O.K.	2	"
65	R.03" TYP				O.K.	2	"
66	R.02" TYP				O.K.	2	"
67	3.026"		+ .010/- .030		O.K.	5	"
68	R.25" TYP				O.K.	2	"
69	1.96"	Section Q-Q			O.K.	2	"
70	R.03" TYP				O.K.	2	"
71	R.02" TYP				O.K.	2	"
72	3.157		+ .010/- .030		O.K.	5	"
73	R.25" TYP				O.K.	2	"
74	1.82"	Section R-R			O.K.	2	"
75	R.03" TYP				O.K.	2	"

# INSPECTION / TEST REPORT

JOB No.

36044C

PAGE: 3 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. P018242

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
----------	----------------	---------	-----------	--------------	--------	------------	---------------------------------

76	R.02" TYP				O.K.	2	Acc. 5
77	3.238"	Section R-R Cont'd	+ .010/- .030		O.K.	5	"
78	R.25" TYP				O.K.	2	"
79	1.48"	Section S-S			O.K.	2	"
80	R.03" TYP				O.K.	2	"
81	R.02" TYP				O.K.	2	"
82	3.358		+ .010/- .030		O.K.	5	"
83	R.25" TYP				O.K.	2	"
84	3.396"		+ .010/- .030		O.K.	5	"
85	R.25" TYP				O.K.	2	"
86	2.00"	Section V-V, W-W			O.K.	2	"
87	R.03" TYP				O.K.	2	"
88	R.02" TYP				O.K.	2	"
89	3.071"		+ .010/- .030		O.K.	5	"
90	R.25" TYP				O.K.	2	"
91							
92							
93							
94							
95							
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107							
108							

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577

\*\*\*OUTSTANDING PO REPRINT\*\*\*

Purchase Order ID PO18242

Purchase Order Date 10/24/12

PO Print Date 2/04/13

Page Number 1 of 1

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD  
600 O'CONNOR DRIVE  
KINGSTON, ONTARIO K7P 1N3  
CANADA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613-384-1662	Requisition Nbr	
Vendor Fax	613-384-2997	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Unit Price	Extended Price
----------	--	------------------------	----------------------	---------	------------	----------------

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
C13/02/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	D3885-3P	Standard Web	2/28/13 Yes	5.00 Each	Day & Ross coll	\$550.0000	\$2,750.00

Special Inst: MACHINE AS PER D3885 REV.B  
B91997

Line Total: \$2,750.00

Outstanding PO Total: \$2,750.00

SP13-4-02

Change Nbr: 5

Change Date: 2/04/13

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required - YES NO